

Work Order ID 145331

Thursday, May 05, 2016 1:34:20 PM

145331

Page 1

Item ID: D205-708-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Adjustable Engine Modification

Start Date: 5/9/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 5/30/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MWJ Date: MAY 06 2016

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

B80701

Rev C

JUL 04 2016

0.00

DAS
6
9-89DAS
27
9-89DAS
21
9-89160704

100

Document Control

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D205-708-011, CHG001

NOV 01 2016

110

0.00

110

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 32350 for:

(ATTN:ORDER THE B P/N'S! - SAME AS BOM)

6	D3284-001	(B80702-1)	Sleeve
2	D3284-003	(B80703-1)	Stud
4	D3284-005	(B80704-1)	Stud
6	D3284-007	(B80705-1)	Stud
6	NAS509-12	Nut	
6	NAS509L12	NutStud	

To be assembled as per Dwg B80701 Rev. C

Possible Supplier: Northern Aero

Certificate of Conformity is required

DAS
13
9-892 MAY 12 2016

Thursday, May 05, 2016 1:34:21 PM

Page 2

JUL 12 2016

Work Order ID 145331

Thursday, May 05, 2016 1:34:21 PM

145331

Page 3

Item ID: D205-708-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Adjustable Engine Modification

Start Date: 5/9/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 5/30/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

QC4- 100% Inspect kits for completeness

0.00

140

QC

Memo

0.06

Quality Control

2
DAS
27
9-89

NOV 01 2016

150

Packaging

0.00

150

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D205-708-011
Location: FG0282
DAS
27
9-89
DAS
28
9-89

NOV 01 2016

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.20

Quality Control

DAS
21
9-89

NOV 01 2016

DAS
21
9-89

NOV 01 2016

Picklist Print

Thursday, May 05, 2016 1:34:24 PM

Page 1

Work Order ID: 145331

145331

Parent Item: D205-708-011

D205-708-011

Parent Item Name: Adjustable Engine Modification

Start Date: 5/9/2016

Required Date: 5/30/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP C 06.01.31 Added MS206136C12 JLM/AP
IPP Rev:D 07-12-12 as per ECN 1074 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
B80702-1 Sleeve DAS 27 9-89		Purchased	No				Each	0.0000	6	12			8008
B80702-1									**	145331			
B80703-1 Stud DAS 27 9-89		Purchased	No				Each	0.0000	2	4			8008
B80703-1									**	145331			
B80704-1 stud DAS 27 9-89		Purchased	No				Each	0.0000	4	8			8008
B80704-1									**	145331			
B80705-1 stud DAS 27 9-89		Purchased	No				Each	0.0000	6	12			8008
B80705-1									**	145331			
D3284-009 Bearing DAS 27 9-89		Manufactured	No			140	Each	2.0000	6	12			8008
D3284-009									**	PC B145236			
Location ST030 141716 Loc Qty 2 2 Loc Code													
D3284-011 Bearing DAS 27 9-89		Manufactured	No			140	Each	3.0000	1	2			8008
D3284-011									**				
Location ST030 115593 Loc Qty 3 3 Loc Code													

JUN 29 2016

JUL 17 2016

Picklist Print

Thursday, May 05, 2016 1:34:24 PM

Page 2

Work Order ID: 145331

145331

Parent Item: D205-708-011

D205-708-011

Parent Item Name: Adjustable Engine Modification

Start Date: 5/9/2016

Required Date: 5/30/2016

Start Qty: 2.00

Required Qty: 2.00

MS20613-6C12

Purchased

No

140

Each

34.0000

2

4

MS20613-6C12

Rivet

DAS
27
9-89

Location

Loc Qty

Loc Code

ST307

34

105433

34

MS20613-6C16

Purchased

No

140

Each

313.0000

8

16

MS20613-6C16

Rivet

DAS
27
9-89

Location

Loc Qty

Loc Code

ST307

313

115358

313

MS20613-6C18

Purchased

No

140

Each

74.0000

4

8

MS20613-6C18

Rivet

DAS
27
9-89

Location

Loc Qty

Loc Code

ST306

74

M125880

74

MS20613-6C19

Purchased

No

140

Each

45.0000

12

24

MS20613-6C19

Rivet

DAS
27
9-89

Location

Loc Qty

Loc Code

ST306

15

m130279

15

ST307

30

120212

30

m130279

0

JUL 12 2016

Thursday, May 05, 2016 1:34:24 PM

Shop Packet Print

Page 2

Picklist Print

Thursday, May 05, 2016 1:34:24 PM

Page 3

Work Order ID: 145331

145331

Parent Item: D205-708-011

D205-708-011

Parent Item Name: Adjustable Engine Modification

Start Date: 5/9/2016

Required Date: 5/30/2016

Start Qty: 2.00

Required Qty: 2.00

NAS509-12	Purchased	No	140	Each	68.0000	6	12	
NAS509-12						**		<u>145333\$ SP</u>
Nut								

DAS
27
9-89

Location

Loc Qty

Loc Code

ST261

68

15057

43

24757

25

NAS509L12	Purchased	No	140	Each	58.0000	6	12	
NAS509L12						**		<u>145331 SP</u>
Nut								

DAS
27
9-89

Location

Loc Qty

Loc Code

ST261

58

102296

26

24757

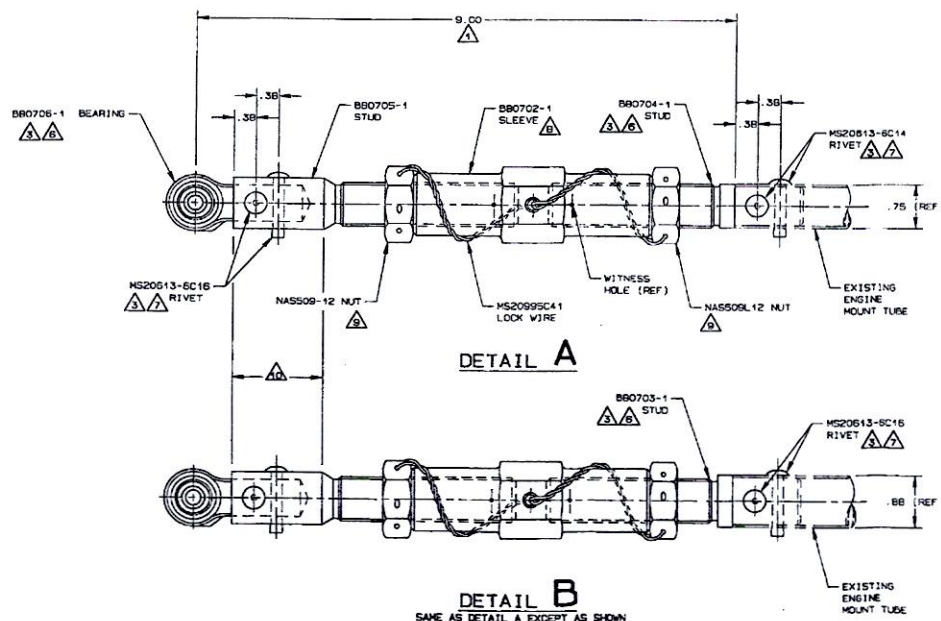
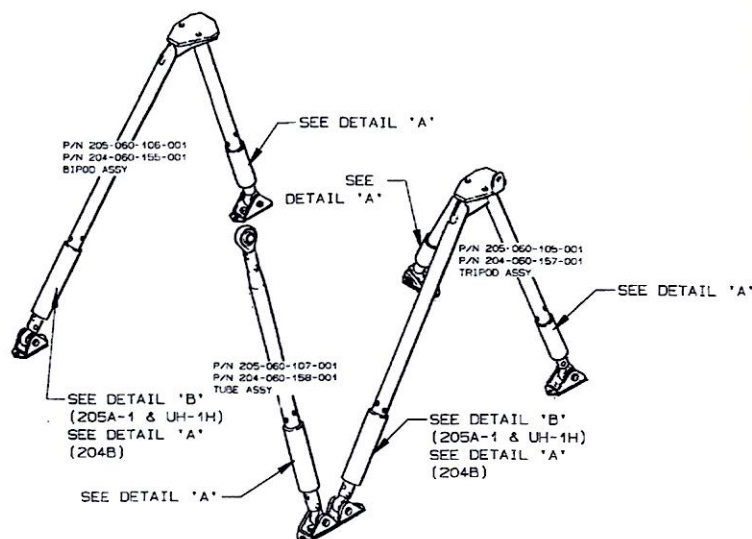
23

94018

9

NOTES:

1. CUT EXISTING ENGINE MOUNT TUBE AT DIMENSION SHOWN.
2. DEBURR OUTSIDE DIAMETER OF TUBE .005/.010 AND CHAMFER INSIDE DIAMETER .015/.025.
3. BOTTOM OUT BEARING IN B80705 STUD AND B80703/B80704 STUD IN TUBE. POSITION RIVET HOLES AS SHOWN AND LINE DRILL PARTS .194 DIA (#10 DRILL).
4. DISASSEMBLE PARTS AND DEBURR.
5. ZINC CHROMATE PRIME TUBE ASSY ALL OVER USING 11-P-1757, COLOUR GREEN.
6. RE-ASSEMBLE PARTS WET WITH HYSOL ADHESIVE EA934.
7. INSTALL RIVETS WET WITH HYSOL ADHESIVE EA934.
8. FILL SLEEVE WITH CORROSION PREVENTIVE COMPOUND MIL-C-16173 SUFFICIENT TO CAUSE SQUEEZE OUT, THEN ASSEMBLE THREADED PARTS AS SHOWN.
9. FOR AIRCRAFT INSTALLATION, BACK OFF NUTS AND ORIENT BEARINGS TO SUIT ENGINE DECK FITTINGS. ADJUST LENGTHS OF INDIVIDUAL TUBES WITH SLEEVE TO OBTAIN CORRECT ENGINE/TRANSMISSION ALIGNMENT PER BELL MAINTENANCE MANUAL. MAKE SURE STUDS ARE STILL VISIBLE THROUGH WITNESS HOLES. TORQUE NUTS 400 TO 600 IN-LBS AND LOCKWIRE AS SHOWN. SEAL LOCKWIRE HOLES IN SLEEVE AND AROUND NUT/THREAD INTERFACE WITH SEALANT PER MIL-S-8802.
10. ZINC CHROMATE WHERE INDICATED USING 11-P-1757, COLOUR GREEN.



NOTICE

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Record of Revisions

REV.	Date	Description of changes	by	approved
N/C	08 JAN 99	INITIAL RELEASE	TM	TIM MARTIN
A	19 MAY 99	REV. MATL LIST, ADD B80706-1 BRG.	GW	TIM MARTIN
B	01 FEB 00	DCN B80701A1 INCORPORATED	TM	TIM MARTIN
C	09 OCT 03	DCN B80701B1 INCPD	TM	Mt

RELEASED FOR
BPMO L1400 C140
OCT 14 2003
AERO CONSULTING SERVICES LTD.

AR	AR	EA934	ADHESIVE	DEXTER/HYSOL
6	6	B80706-1	BEARING	ACS
AR	AR		SEALANT	MIL-S-8802, CLASS B
AR	AR		CORROSION PREVENTIVE COMPOUND	MIL-C-16173, GRADE 1
AR	AR	MS20995C41	LOCK WIRE	
12	8	MS20613-8C14	RIVET	
12	16	MS20613-8C16	RIVET	
6	6	NASS09L12	NUT	
6	6	NASS06-12	NUT	
6	6	B80705-1	STUD	
6	4	B80704-1	STUD	
	2	B80703-1	STUD	
6	6	B80702-1	SLEEVE	
\		-3	INSTALLATION	
\		-1	INSTALLATION	
-3	-1	PART NO.	DESCRIPTION	MATERIAL
LIST OF MATERIALS				
APPROVALS		DATE		
DRAWN: T MARTIN		27 JAN 99		
CHECKED:				
PROJECT ENGINEER:				
STRESS:				
AVIONICS:				
NORTH AERO INDUSTRIES		1845 ST. MATTHEWS AVENUE		
WINNIPEG, MANITOBA R3M 0A8		INSTALLATION - ENGINE MOUNT, ADJUSTABLE, BELL 204/205		
CODE IDENT NO.		REV. NO.		REV.
36929		B80701		C
SCALE: FULL		SHEET 1 OF 1		

SPECIFICATION CONTROL DRAWING

DART P/N	SPECIFICATION
D3284-001 SLEEVE	ACS P/N B80702-1 PER ACS DWG B80702 REV. A
D3284-003 STUD	ACS P/N B80703-1 PER ACS DWG B80703 REV. A
D3284-005 STUD	ACS P/N B80704-1 PER ACS DWG B80704 REV. A
D3284-007 STUD	ACS P/N B80705-1 PER ACS DWG B80705 REV. B
D3284-009 BEARING	BHT P/N 47-140-252-5
D3284-011 BEARING	BHT P/N 205-060-101-001
D3284-021 TUBE ASSY	204-060-158-001 MODIFIED PER IIN-D205-708
D3284-023 BIPOD ASSY	204-060-155-001 MODIFIED PER IIN-D205-708
D3284-025 TRIPOD ASSY	204-060-157-001 MODIFIED PER IIN-D205-708
D3284-031 TUBE ASSY	205-060-107-001 MODIFIED PER IIN-D205-708
D3284-033 BIPOD ASSY	205-060-106-001 MODIFIED PER IIN-D205-708
D3284-035 TRIPOD ASSY	205-060-105-001 MODIFIED PER IIN-D205-708



NOTE:

FOR FUTURE PROCUREMENT, THE PURCHASE ORDER MUST SPECIFY THAT THE MATERIAL USED TO MANUFACTURE THE D3284-001/-003/-005/-007 PARTS MUST COMPLY WITH THE FOLLOWING SPECIFICATIONS:

AISI 4130 ROUND BAR PER AMS 6348/MIL-S-6758 WITH

MIN F_{tu} = 90 Ksi

MIN F_{ty} = 70 Ksi

EACH INDIVIDUAL ITEM TESTED BEFORE USE OR PROVEN TO EQUAL OR EXCEED THE ABOVE.

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 145331.MLS
 1605-06

RELEASED

2010-03-25

B	ADD NOTE	RF	09.07.14
A	NEW ISSUE	KJ	04.05.06
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO. REV. B	
MFG. APPR.		D3284 SHEET 1 OF 1	
APPROVED		TITLE SCALE	
DE APPR.		ADJUSTABLE ENGINE MOUNT NTS	
DATE	09.07.14	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



25 Dunlop Ave
Winnipeg, Manitoba, Canada, R2X 2V2
Ph: 204-783-5402 Fax: 204-783-5436

STATEMENT OF CONFORMITY

Form Tracking No. 35703-1

Work Order/Contract/Invoice
PO: 32350

Production Order: On File

Item	Description	Part No.	Quantity	Serial/Batch	Status
1	Sleeve, Engine Mount	B80702-1	12	14-2942	New
2	Stud, Male, 7/8, Engine Mount	B80703-1	4	14-3186	New
3	Stud, Male, 3/4, Engine Mount	B80704-1	4	14-3186	New
4	Stud, Male, 3/4, Engine Mount	B80704-1	2	14-3116	New
5	Stud, Male, 3/4, Engine Mount	B80704-1	2	14-2944	New
6	Stud, Female, Engine Mount	B80705-1	12	14-3335	New

Remarks:

The above items conform to Released Design Data in accordance with DWG B80702 (Rev. A), DWG B80703 (Rev. A), DWG B80704 (Rev. A), and DWG B80705 (Rev. B); as applicable.

New-Unused Parts/Material Certification

The items described above have been manufactured using standards employed B/E Aerospace (previously EMTEQ) in accordance with AS9100 Quality Assurance System.

Signature

Name: Tim Sinclair

Date: 27 Jun 16

User/Installer Responsibilities: This certificate does not constitute authority to install the item(s) described above on an in-service type certified aircraft.



Passion to Innovate.
Power to Deliver.

Packing Slip

AEROSPACE

B/E Aerospace Limited

25 Dunlop Avenue

R2X 2V2 Winnipeg

Canada

Tel : 204-783-5402

Fax : 204-783-5436

Delivery No. : 6778
Delivery Date : 06/24/2016
SO No. : 35703
Your Reference : PO 32350
Delivery Method : FEDEX
Payment Condition : Net 30 Days

Delivery to: Dart Aerospace Ltd.

Attention:Accounts

1270 Aberdeen Street *32350*

Hawkesbury K6A 1K7

Canada

Item	Description Batch Number	Total Ordered	Unit	Qty Delivered	Delivery Date
B80702-1	SLEEVE, ENGINE MOUNT 14-2942	12	EA	12	07/08/2016
B80703-1	STUD, MALE, 7/8, ENGINE MOUNT 14-3187	4	EA	4	07/08/2016
B80704-1	STUD, MALE, 3/4, ENGINE MOUNT 14-3186 14-3116 14-2944	8	EA	8	07/08/2016
B80705-1	STUD, FEMALE, ENGINE MOUNT 14-3335	12	EA	12	07/08/2016
NAS509-12	NUT (.7500-16 UNJF-3B) 13-1954	12	EA	12	07/08/2016
NAS509-L12	NUT STEEL (.7500-16 UNJF-3B-LH) LH THREAD 13-2349	12	EA	12	07/08/2016
MISC CHARGES - NAI	Misc Charges Chantal Lavoie 613-632-5200 clavoie@dartaero.com Ship Via: Fed Ex OVERNIGHT collect Customer Tax#: 10127-2607 REQUIRED C of C	2	-	2	07/08/2016

16/10/20
SP

Ordered by: Dart Aerospace Ltd.

Attention: Accounts

1270 Aberdeen Street

Hawkesbury K6A 1K7

Canada

Invoice to: Dart Aerospace Ltd.

Attention: Accounts

1270 Aberdeen Street

Hawkesbury K6A 1K7

Canada

Remarks

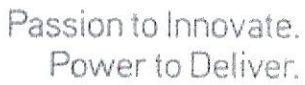
Certification Statement

I hereby certify that the aircraft part(s) described hereon were acquired from a source of supply that is consistent with the conditions under which TCCA distributor approval AMO88-97 has been granted. *P/N NAS509-12 / NAS509-L-12*

Signatory

Date:

JUN 25 2016



Fax : 204-783-5436

Delivery No.	:	6778
Delivery Date	:	06/24/2016
SO No.	:	35703
Your Reference	:	PO 32350
Delivery Method	:	FEDEX
Payment Condition	:	Net 30 Days

Date:



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO32350

Purchase Order Date 5/12/2016

PO Print Date 5/12/2016

Page Number 1 of 4

Order From :

VU-ACS001

B/E AEROSPACE
25 DUNLOP AVENUE
WINNIPEG, MB R2X 2V2

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED

MAY 12 2016

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	204-772-9922	Customer POID	
		Customer Tax #	10127-2607
Ship To Contact		Terms	Net 30
Ship To Phone		Currency	USD
Ship Via:	FedEx Overnight collect	FOB	FCA - (Free Carrier)
Ship Acct:			

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	B80702-1	Sleeve	5/26/2016 Yes 5/26/2016		12.00 Each	\$156.00	\$1,872.00
AS PER DWG D3284 REV. C B145331 D3284-001 SLEEVE, SPEC'S ACS P/N B80702-1 PER ACS DWG B80702 REV. A							Line Total: \$1,872.00
2	B80703-1	Stud	5/26/2016 Yes 5/26/2016		4.00 Each	\$98.00	\$392.00
AS PER DWG D3284 REV. C B145331 D3284-003 STUD, SPEC'S ACS P/N B80703-1 PER ACS DWG B80703 REV. A							Line Total: \$392.00

Note:

5/12/2016



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO32350**

Purchase Order Date 5/12/2016

PO Print Date 5/12/2016

Page Number 2 of 4

Order From :

B/E AEROSPACE
25 DUNLOP AVENUE
WINNIPEG, MB R2X 2V2

VU-ACS001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 204-772-9922

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

USD

FOB

FCA - (Free Carrier)

3	B80704-1	stud	5/26/2016	8.00	✓	\$87.00	\$696.00
			Yes	Each			
			5/26/2016				

AS PER DWG D3284 REV. C
B145331

D3284-005 STUD, SPEC'S ACS P/N B80704-1 PER ACS DWG B8070 REV. A

Line Total: \$696.00

4	B80705-1	stud	5/26/2016	12.00	✓	\$99.55	\$1,194.62
			Yes	Each			
			5/26/2016				

AS PER DWG D3284 REV. C
B145331

D3284-007 STUD, SPEC'S ACS P/N B80705-1 PER ACS DWG B80705 REV. B

Line Total: \$1,194.62

5	NAS509-12	Nut	5/26/2016	12.00	✓	\$11.62	\$139.42
			Yes	Each			
			5/26/2016				

16/6/29
SEP

Note:

5/12/2016



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO32350**

Purchase Order Date 5/12/2016

PO Print Date 5/12/2016

Page Number 3 of 4

Order From :
B/E AEROSPACE
25 DUNLOP AVENUE
WINNIPEG, MB R2X 2V2

VU-ACS001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

204-772-9922

Ship To Contact

Ship To Phone

Ship Via:

FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

USD

FOB

FCA - (Free Carrier)

					Line Total:	\$139.42	
6	NAS509L12	Nut	5/26/2016	12.00	/	\$22.43	\$269.16
			Yes	Each			
			5/26/2016				
					Line Total:	\$269.16	
7	145331	ASSEMBLE AS PER DWG	5/26/2016	2.00	/	\$25.00	\$50.00
			Yes				
			5/26/2016				
					16/2/29 CP	Line Total:	\$50.00

Note:

5/12/2016



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO32350

Purchase Order Date 5/12/2016

PO Print Date 5/12/2016

Page Number 4 of 4

Order From :
B/E AEROSPACE
25 DUNLOP AVENUE
WINNIPEG, MB R2X 2V2

VU-ACS001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 204-772-9922

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Customer POID

Customer Tax # 10127-2607

Terms Net 30

Currency USD

FOB FCA - (Free Carrier)

Chantal Lavoie

8	71401-45	PROCUREMENT QUALITY CLAUSES	5/26/2016	1.00	\$0.00	\$0.00
---	----------	--------------------------------	-----------	------	--------	--------

No

5/26/2016

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A016 PERSONNEL QUALIFICATION

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

Line Total: \$0.00

PO Total: \$4,613.20

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 1

Change Date: 5/12/2016

Work Order ID 145331

Thursday, May 05, 2016 1:34:20 PM

145331

Page 1

Item ID: D205-708-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Adjustable Engine Modification

Start Date: 5/9/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 5/30/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MCS Date: MAY 06 2016

Tooling:

Date:

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision-Nbr
B80701	Rev C

100	Document Control	0.00							
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100

DC

Doc.Control -USB or Paperwork

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile and create labels per PPP D205-708-011, CHG001

DAS
21
9-89

JUL 04 2016

110	PURCHASING	0.00							
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110

Purchasing

Purchasing

PURCHASING

Memo

0.00

Issue P/O: 32350 for:
(ATTN:ORDER THE B P/N'S! - SAME AS BOM)
6 D3284-001 (B80702-1) Sleeve
2 D3284-003 (B80703-1) Stud
4 D3284-005 (B80704-1) Stud
6 D3284-007 (B80705-1) Stud
6 NAS509-12 Nut
6 NAS509L12 NutStud

To be assembled as per Dwg B80701 Rev. C
Possible Supplier: Northern Aero
Certificate of Conformity is required

2

MAY 12 2016

DAS
13
9-89

4.0 PARTS LIST

Qty -043	Qty -013	Qty -041	Qty -011	Part Number	Description
			X	D205-708-011	ADJUSTABLE ENGINE MOUNT KIT (205/UH-1)
		X		D205-708-041	ADJUSTABLE ENGINE MOUNT ASSEMBLY (205/UH-1)
	X			D204-708-013	ADJUSTABLE ENGINE MOUNT KIT (204)
X				D204-708-043	ADJUSTABLE ENGINE MOUNT ASSEMBLY (204)
	6		6	D3284-001	SLEEVE
			2	D3284-003	STUD
	6		4	D3284-005	STUD
	6		6	D3284-007	STUD
	6		6	D3284-009	BEARING
	1		1	D3284-011	BEARING
1				D3284-021	TUBE ASSEMBLY
1				D3284-023	BIPOD ASSEMBLY
1				D3284-025	TRIPOD ASSEMBLY
		1		D3284-031	TUBE ASSEMBLY
		1		D3284-033	BIPOD ASSEMBLY
		1		D3284-035	TRIPOD ASSEMBLY
	2		2	MS20613-6C12	RIVET
	12		8	MS20613-6C16	RIVET
			8	MS20613-6C18	RIVET
	12		8	MS20613-6C19	RIVET
	6		6	NAS509-12	NUT
	6		6	NAS509L12	NUT

5.0 WEIGHT AND BALANCE

The following is the net weight and moment change associated with this installation

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-708-011 Adjustable Engine Mount Kit (205/UH-1)	9.6 lb 4.4 kg	-3.0 in -0.08 m	-28.8 lb-in -0.35 kg-m	188.5 in 4.79 m	1810 lb-in 21.1 kg-m
D205-708-041 Adjustable Engine Mount Assembly (205/UH-1)					
D204-708-013 Adjustable Engine Mount Kit (204)	9.6 lb 4.4 kg	-3.0 in -0.08 m	-28.8 lb-in -0.35 kg-m	184.5 in 4.69 m	1771 lb-in 20.6 kg-m
D204-708-043 Adjustable Engine Mount Assembly (204)					